

Date: Thursday, 3/9/2006 8:38:07 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE BRACKET
Job Number	: 26184		
Estimate Number	: 12256		
P.O. Number	: N/A	Part Number	: D3481041
This Issue	: 3/9/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3481 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>SEE ABOVE. USE & DATE</u>	Qty:	5 Um: Each
Comment	: Est Rev: A New Issue 06-02-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3481043	bracket & clamp ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3481-3043	Bracket Assembly	B26294

✓ 060329 ⑤

2.0	BACN10YD3	CLIP FLOATING NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	BACN10YD3	Clip	M19596

✓ 060329 ⑤

3.0	AN33A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-3A	Bolt	M16895 / M100117

✓ 060329 ⑤

4.0	AN96010	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-10	Washer	M5519

✓ 060329 ⑤

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/03/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:38:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE BRACKET

Job Number: 26184

Part Number: D3481041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34811	Shut-off valve
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3481-1	Bracket	B26105

AB 0603-29 (5)

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

AB 0603-29 (5)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

50607.30 (5)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 440

C 506103/30 (5)

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

D 506103/31 (5)

Job Completion



U 06.03/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

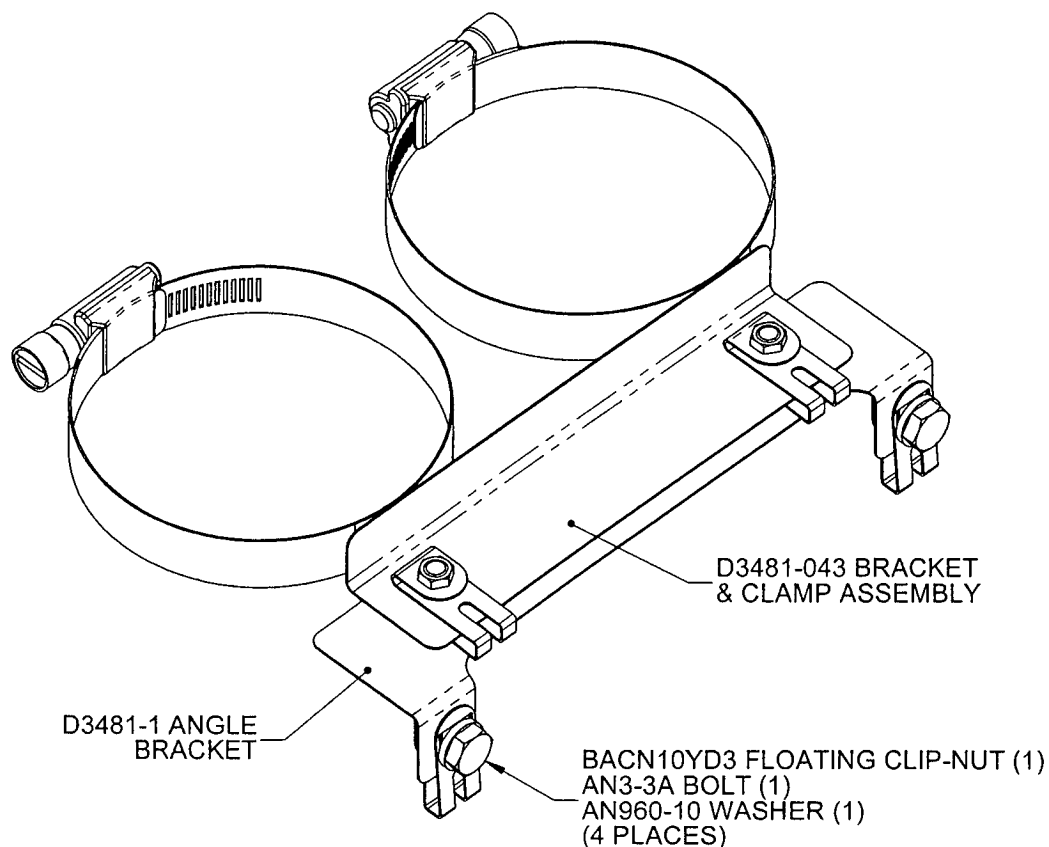
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

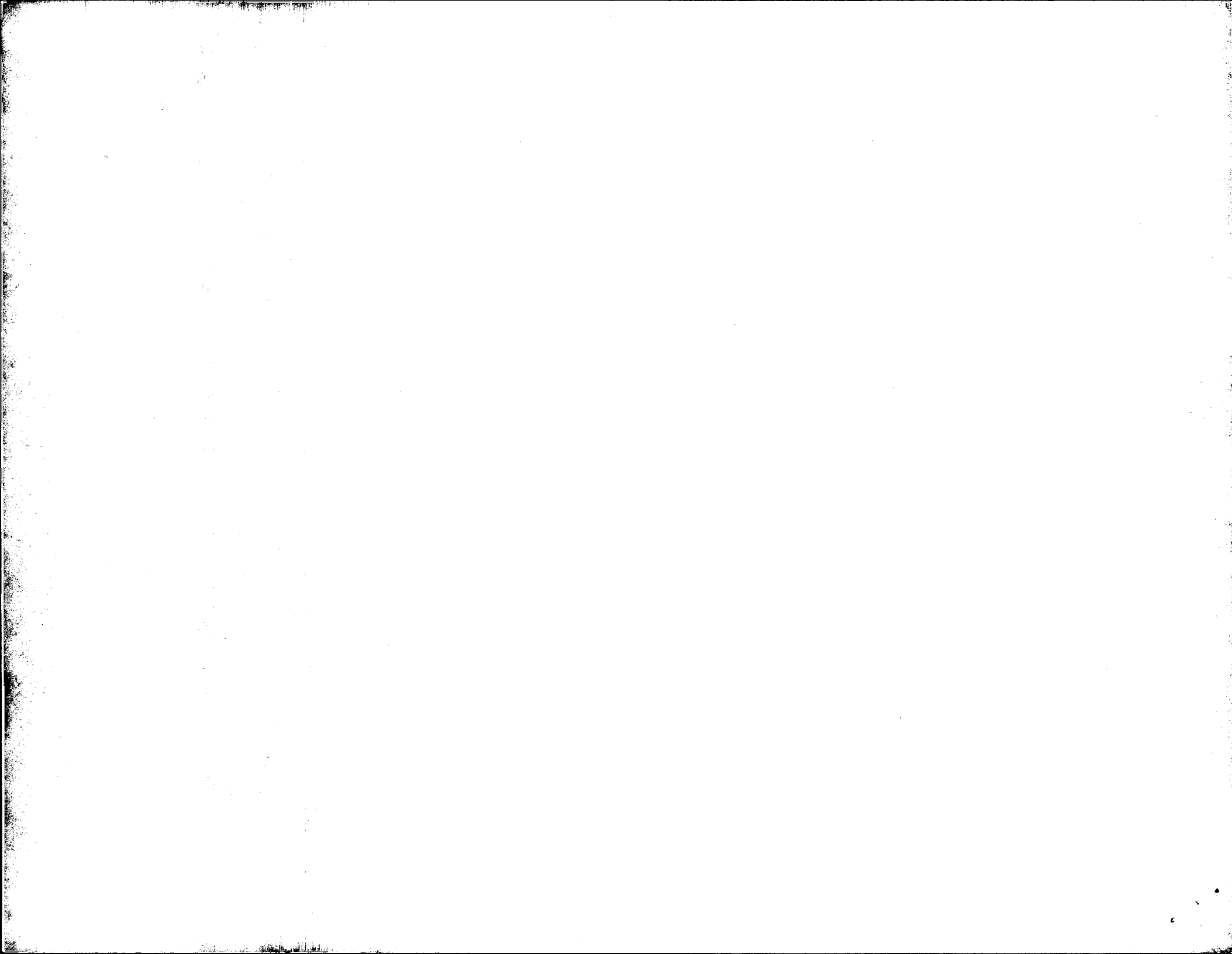
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:1.5
A	06.01.23	NEW ISSUE	

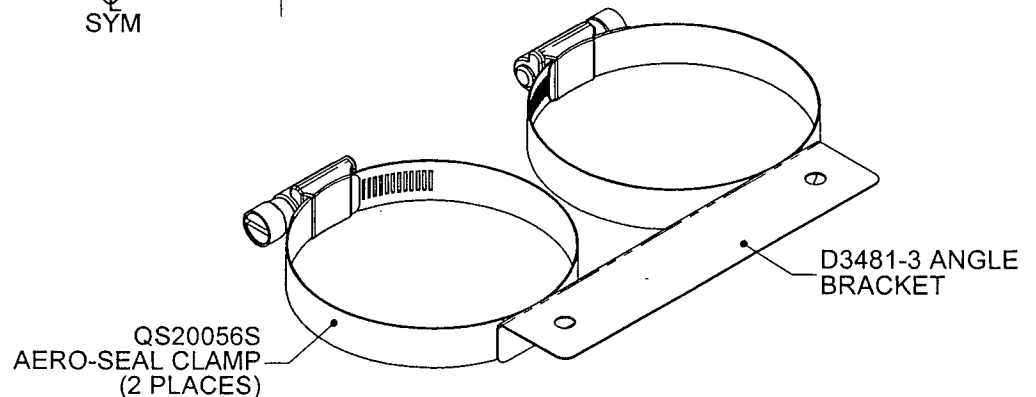
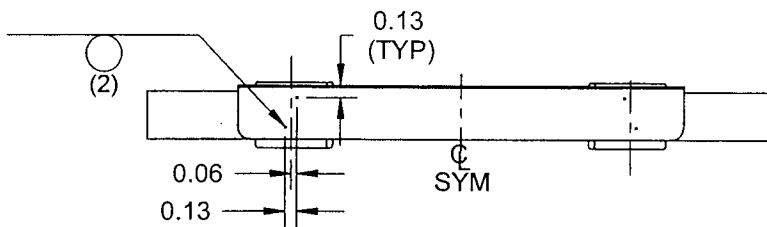
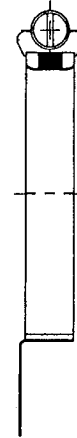
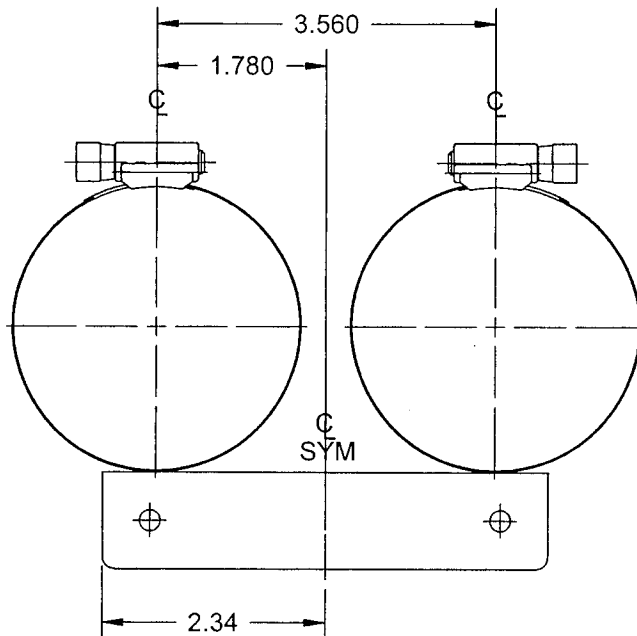


D3481-041 SHUT-OFF VALVE BRACKET



PRELIMINARY ISSUE

DESIGN 5	DRAWN BY 5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3481	REV. A SHEET 2 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

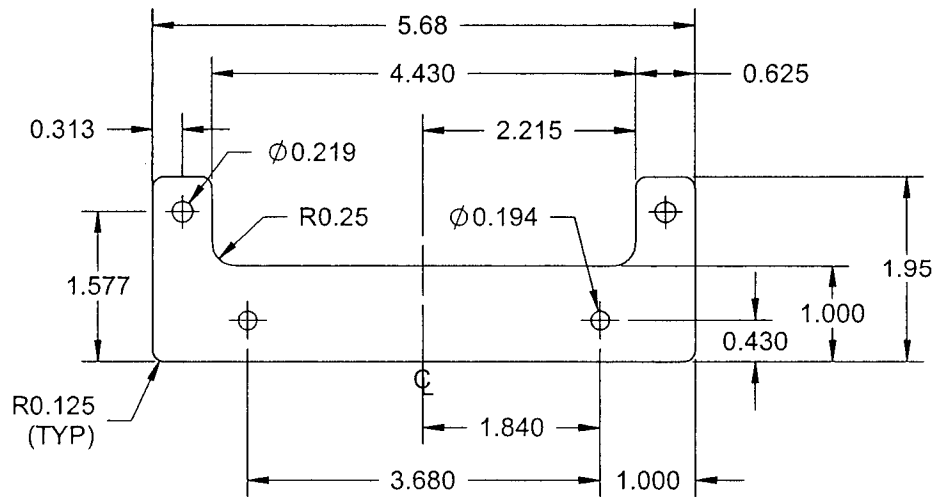
- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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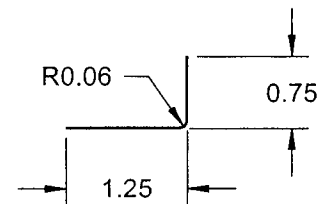
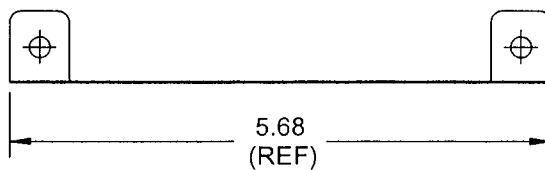
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PRELIMINARY ISSUE

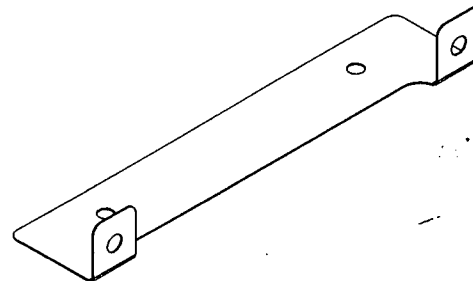
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3481	REV. A SHEET 3 OF 4
DATE 06.01.20		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-1F FLAT PATTERN



D3481-1 ANGLE BRACKET



NOTES:

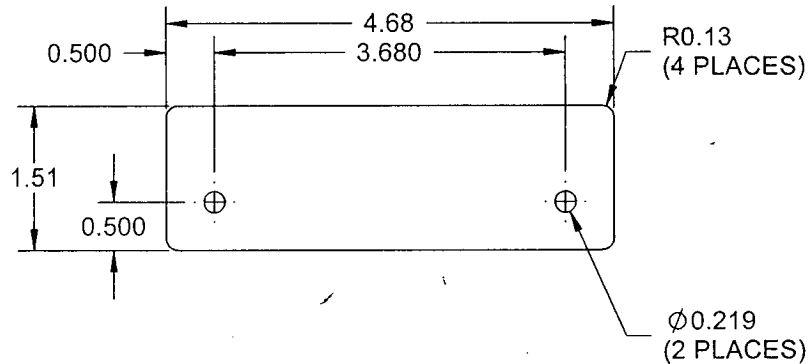
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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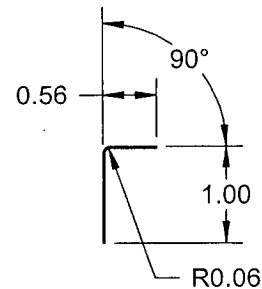
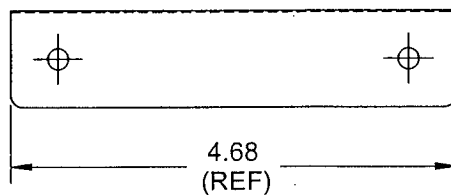
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PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3481	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

